

Date: Thursday, 16/10/2008 10:44:13 AM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY		
Job Number	42628B					
Estimate Number	10207					
P.O. Number	:					
This Issue	16/10/2008	S.O. No. :	Part Number	: D2989043		
Prsht Rev.	NC					
First Issue	/ /	Type : LARGE FAB ASSY	Drawing Number	: D2989 REV C		
Previous Run	42625B					
Written By	:				Project Number	: N/A
Checked & Approved By	: JUL 08.10.16			Drawing Revision	: C	
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM			Material	:	
	Est Rev:J 08-08-29 revC as per dwg DD verified by:EC			Due Date	: 05/11/2008	
	Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC			Qty:	1	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31821	Hinge	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Pick:		
	✓ Qty Part number	Description Batch	
	2 D3182-1	Hinge	<i>B39336</i>
			<i>JL 08/11/14</i>
2.0	D34423	Shim	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Pick:		
	✓ Qty Part number	Description Batch	
	2 D3442-3	Shim	<i>B42718</i>
			<i>JL 08/11/14</i>
3.0	M304EX07516F	Expanded Metal Flat SS	
	Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)		
	Pick:		
	✗ Qty Part number	Description Batch	m109383
	8sf M304EX0.75-16F	Expanded Metal	<i>m109383</i>
			<i>SAD 08-11-13</i>
4.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
	Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)		
	3/4" x 3/4" x 0.065" wall 304/316 SStubing.		
	Batch: <i>m10973</i>		<i>SAD 08/11/10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/10/2008 10:44:13 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 42628B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

SL 08/11/17

6.0 QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

7.0 QC6



DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0 POWDER COATING



POWDER COATING



Comment: POWDER COATING

1- Plug holes in D2989-17 and D2989-2 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45
400°F

9:15

2nd coat if necessary

10:00

400°F

10:30

ML 08/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 42628B

Part Number: D2989043

Job Number:



Seq. #:	Machine Or Operation:	Description :
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 8/11/20
	Comment: Inspect Powder Coat	
10.0	QC21	FINAL INSPECTION/W/O RELEASE
		 08/11/24 JJ
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D

D

C

C

B

B

A

A

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2989-041	BASKET LID ASSEMBLY
X		D2989-043	BASKET LID ASSEMBLY
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2	2	D2989-17	STRUT
2		D2989-19	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
2		D3182-1	HINGE
2		D3442-3	SHIM

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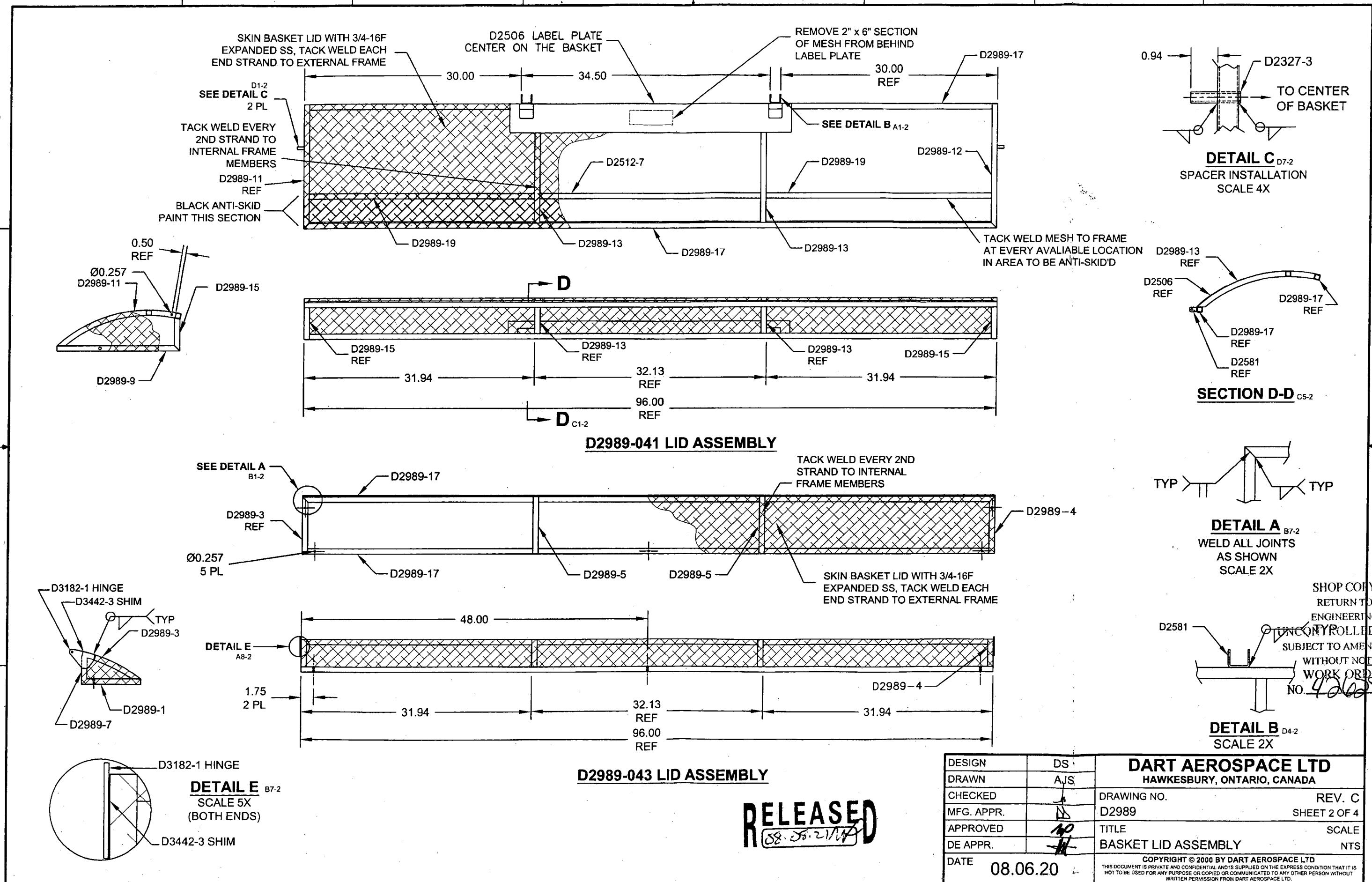
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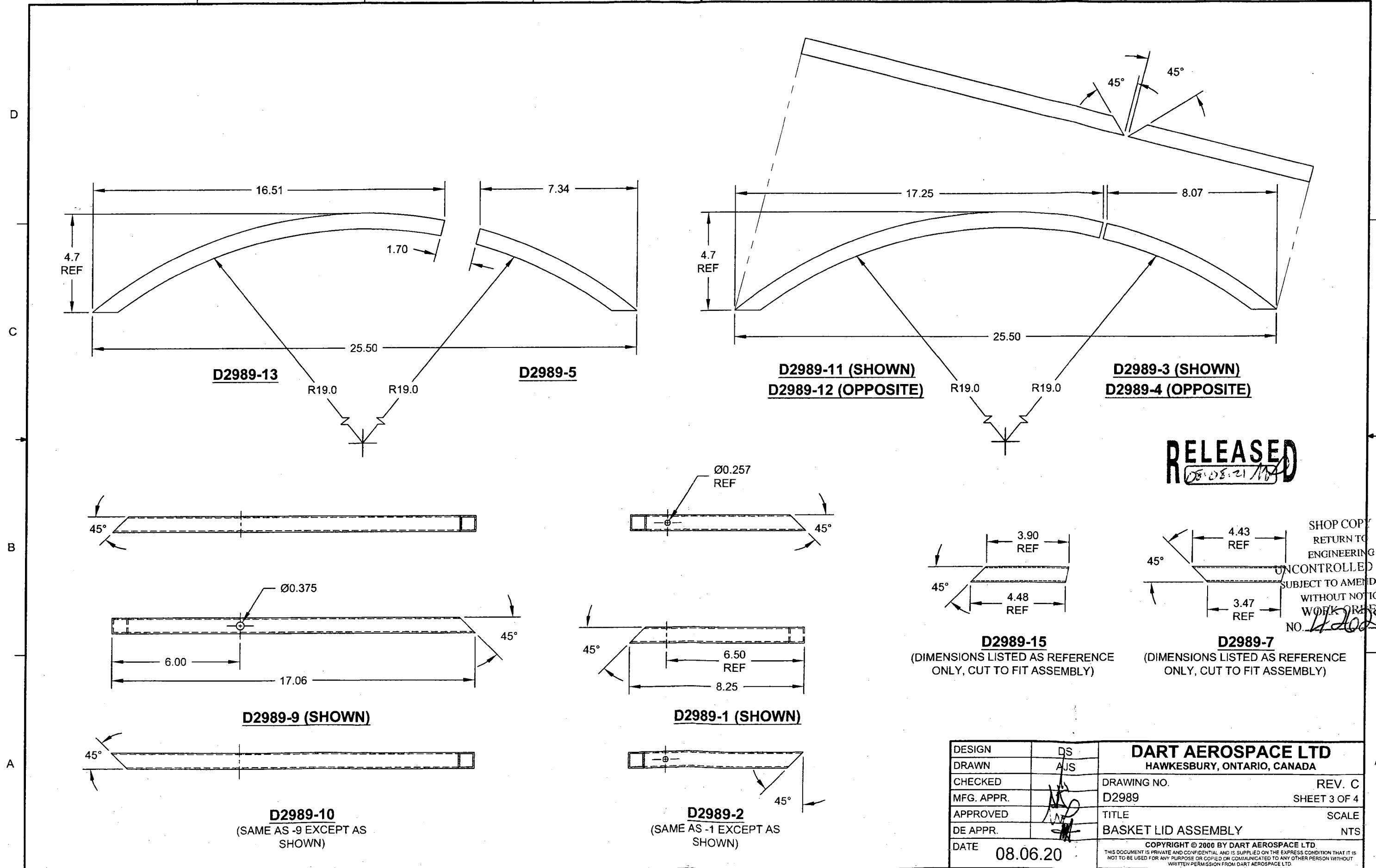
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2989	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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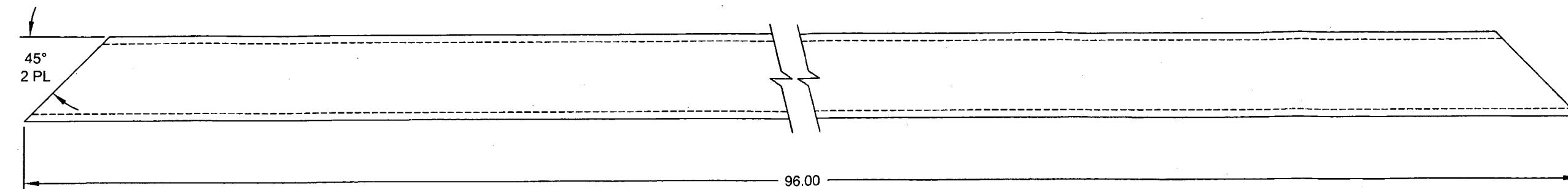


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DE APPR.		SHEET 3 OF 4
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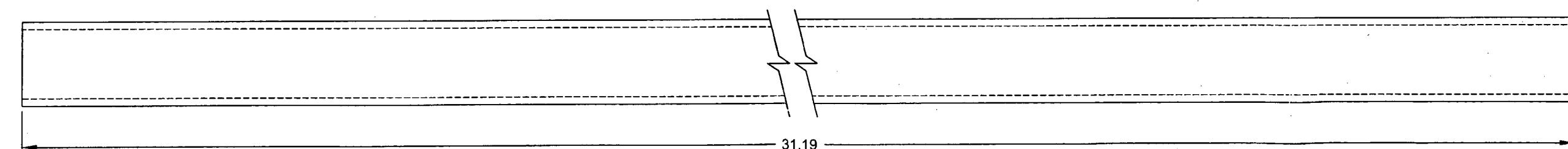
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D2989-17 STRUT

C

C



D2989-19 STRUT

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